



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5785-3

Job Sheet 207418



Part No: D5785-3

Job Qty: 10 pcs

Part Name: Support

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

Part Weight: 0 lbs

Status: New

RELEASED _____ DATE _____

Job Created: 2/25/20

Job Tracking No:

Priority: Medium

Due Date: 3/6/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: URF 20-522 DWG 5785 REV.A IPP REV:A NEW ISSUE 20.01.14 JV VERF:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	10 pcs		3/6/20	0.50	0.40	Hardinge - 1		
110	QC 2	10 pcs		3/6/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



Container No: S259192



Part: D5785-3

Job No: 207418

Serial No/Batch: S259192

Revision: REV.A

Inspector:

Exp Date:

Instructions:

Date: 02/27/20

PRIORITY

Plex 2/26/20 10:05 AM Dart.lajeunesse.marie

120 QC 8	10 pcs	3/6/20	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 8 - 12	
				QC 8 - 14	20/02/29
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Packaging 3-1 - Stock - B4B	10 pcs	3/6/20	0.00 0.00	Packaging 3 - 1 - B4B	MA
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	

2/26/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	10 pcs	3/6/20	0.00 0.00	QC 21 - SA - 21	9-28
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-28
Part Op 100 - 1-Machine as per folio F _____ FOLIO REV: <u>NA</u> DWG REV: <u>A</u> 2-Debur Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - (QC8- Inspect parts - second check) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304R0.313	304 SS Round bar .313	.8750 ft (.0875 ea)	100-Hardinge - 1	S 123400	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Hardinge - 1	M304R0.313	1	12	0	
Part Specifications					
Specifications could not be found.					

Plex 2/26/20 10:05 AM Dart.lajeunesse.marie

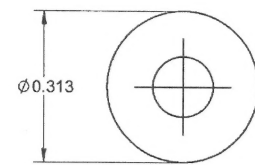
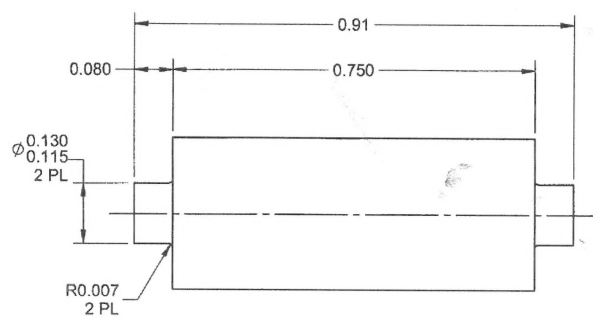
8 7 6 5 4 3 2 1

D

C

B

A



D5785-3 SUPPORT
(DERIVED FROM AERO DESIGN P/N 36275-02)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 207418
MLW
20-02-26

UNDER REVIEW
URF 2020-522 20.02.14 (NO)

RELEASED
2020 FEB 18 *NR*

- NOTES:**
- 1) MATERIAL: 304/316 STAINLESS STEEL ROUND BAR
PER ASTM A276 OR ASTM A479
REF DART SPEC M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.02 lbs

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5785	SHEET 3 OF 3
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	HANDLE BRACKET	NTS
DATE	20.01.09	COPYRIGHT © 2020 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMINGLED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041482

Items												
Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5 AT		M304B0.750X1.000		304 Bar 0.750 X 1.000" : MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 SS PLATE AS PER ASTM A276 OR ASTM A240 NOTE: AISI 303 NOT ACCEPTABLE receive ft	Firmed	-	11/1/18	12 ft	0 ft	12 ft	\$12.136666/ft	\$145.64
6 AT		M304B1.000X1.250		304 Bar 1.000 X 1.250" : MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 SS PLATE AS PER ASTM A276 OR ASTM A240 NOTE: AISI 303 NOT ACCEPTABLE receive ft	Firmed	-	11/1/18	12 ft	0 ft	12 ft	\$20.227/ft	\$242.72
7 AT		M304R0.313		304 SS Round bar .313 : MATERIAL: AISI 304/316 SS ROUND BAR AS PER ASTM A276 NOTE: AISI 303 NOT ACCEPTABLE receive ft	Firmed	-	11/1/18	12 ft	0 ft	12 ft	\$0.91/ft	\$10.92
8 AT		M303R0.500		303 Round Bar 0.500" : MATERIAL: AISI 303 SS ROUND BAR AS PER ASTM A582 NOTE: 304/316 NOT ACCEPTABLE receive ft	Firmed	-	11/1/18	36 ft	0 ft	36 ft	\$2.834/ft	\$102.02
9 AT		M303R1.000		303 Round Bar 1.00 : MATERIAL: AISI 303 SS ROUND BAR AS PER ASTM A582 NOTE: 304/316 NOT ACCEPTABLE receive ft	Firmed	-	11/1/18	24 ft	0 ft	24 ft	\$10.145/ft	\$243.48
10 AT		M303R0.750		303 Round Bar 0.750 : MATERIAL: AISI 303 SS ROUND BAR AS PER ASTM A582 NOTE: 304/316 NOT ACCEPTABLE receive ft	Firmed	-	11/1/18	24 ft	0 ft	24 ft	\$5.406/ft	\$129.74
11		M303B1.000X03.000		303 Bar 1" X 3" : MATERIAL: AISI 303 SS BAR AS PER ASTM A582 NOTE: AISI 304/316 NOT ACCEPTABLE receive ft	Firmed	-	11/1/18	12 ft	0 ft	12 ft	\$48.785/ft	\$585.42
12 AT		M4130NT0.500W.083		4130 Round Tube .500 X .083W : MATERIAL: AISI 4130N STEEL TUBING AS PER MIL-T-6736 OR AMS 6371/6360/6361/6362 6373/6374 receive ft	Firmed	-	11/12/18	100 ft	0 ft	100 ft	\$14.50/ft	\$1,450.00

**ACIER OUELLETTE INC.**

935, Boul. du H vre
Salaberry de Valleyfield (Qu bec) J6S 5L1
T l.: 450-377-4248 M l: 514-336-4248 Ext.: 800-667-4248
Fax: 450-377-5696 M l: 514-336-4246 Ext.: 866-456-4242

Order - Factory

CO00117760

Billed to

DART AEROSPACE LTD

1270 , ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

F-M

Shipped to

1270 , ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Att : PATRICK LUSSIER T l.: (613) 632-5200 X 730

Delivery Route 5**Customer N ****Date****Delivery date****Your order N ****Processed by****Salesman****Carrier****Credit Terme**

CLI0001056

2018/10/29

2018/10/30

PO041482

Denis Quenneville

OUELLETTE VALLEYFIELD

Net 30 Days

Product Description	Weight	Qty	UM	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
1 HR SHEET 11G (4 X 8) FEH-11G48 1 FEUILLE 48 X 96 heat: 152886 2984	160.00	32.00	PI2_\$CLB	32.00							
2 PLATE 44W 5/8 RANDOM P44-58-V 1 PL. 4' X 4' heat: 6913D4 4128	408.00	16.00	PI2_\$CLB	16.00							
3 ROUND CR 1 5/8 1018 (R) RCR-158 1 X 12' heat: 41299AG 5283	84.60	12.00	PI_\$CLB	12.00							
4 ROUND SS 5/16 304 (R) RSS-516 1 X heat: 46862 5773	3.12	12.00	PI_\$CLB	12.00							
5 ROUND SS 1/2 303 (R) RSS-12303 3 X heat: 891B / 936L 5727	24.01	36.00	PI_\$CLB	36.00							
6 ROUND SS 1 303 (R) RSS-1303 2 X heat: 923K 8519	64.08	24.00	PI_\$CLB	24.00							
7 ROUND SS 3/4 303 (R) RSS-34303 2 X heat: 5J049 5761	36.05	24.00	PI_\$CLB	24.00							
8 ROUND ALU 1 6061-T6 * RAL-1 1 X 20' heat: SXE171894 5141	18.50	20.00	PI_\$CLB	25.00							
9 ROUND ALU 1 1/8 6061-T6 * RAL-118 1 x 20' + 1 x 5' heat: Z00238076 5124	29.18	25.00	PI_\$CLB	25.00							
10 ROUND ALU 1 1/2 6061-T6 * RAL-112 1 X 15' heat: SXF180601 5119	31.14	15.00	PI_\$CLB	15.00							

5773

RSS-516

Fidelity C18636

17692

51540

VIRAJ PROFILES LIMITED**VIRAJ**

Works: SURVEY NO.- 25/1, 25/2, 26 & 34, Village- MAAN, Taluka- PALGHAR, Dist.- THANE, MAHARASHTRA -401 506, INDIA,
e-mail- vielqc@viraj.com

TEST CERTIFICATE

ORDER NO	PACKING LIST NO	INSPECTION NO	DATE
P006160	64/75011211/23	100008823006	05.09.2017
		GRADE	HEAT No
		T-304/304L	46862

BUNDLE NO :
1100756952, 1100756951, 1100756950, 1100756949,

DESCRIPTION

STAINLESS STEEL BRIGHT BARS

COLD DRAWN POLISHED - 2H

SIZE	SHAPE	TOLERANCE	LENGTH	PIECES	WEIGHT
5/16"	ROUND	ASTM A484	12' - 14'	1296	4,083.000 LB

CHEMICAL ANALYSIS

%C	%Mn	%Si	%S	%P	%Cr	%Ni	%Cu	%Mo	%Co	%N2
0.0150	1.530	0.260	0.0240	0.0340	18.260	8.030	0.680	0.370	0.140	0.08500

TEST RESULTS

0.2% yield strength ksi	Tensile Strength ksi	Elongation %	Reduction Of Area %	Hardness BHN	Grain Size NOS
94.0	109.0	43.0	73.0	224.0	7.0

SPECIFICATION:

MATERIAL CONFIRMS TO DIN EN 10088-3:2005:WNR 1.4301/1.4307, EN 10222-5 AND EN 10272 COND-A & ASTM A182/A182M-16, ASTM A276/A276M-17 COND A, ASTM A479/A479M-17 COND A, A193/A193M-16, B8 CL-1, A320/A320M-15a, B8 CL-1, A484 16, A388/A388M-05, ASME SA182-14, SA479-15, SA 193-11 B8 CL-1, SA320-11 B8 CL-1, ASTM A314-2008, IGC SATISFACTORY AS PER ASTM A 262-10 PRACTICE E, AMS 5639H/AMS5647J (EXCEPT MARKING), QQ-S-763F, NACE MR0103-2012, NACE-MR0175/ISO-15156-2015, SAB-AMS-S-7720A, MIL-S-862-B, AISI 304/304L & UNS#S30400/S30403. CERTIFICATION AS PER EN 10204-3.1.

REMARKS

MATERIAL IS FREE FROM MERCURY CONTAMINATION, FREE FROM WELD OR WELD REPAIRS, MICRO:FREE FROM CONTINUOUS CARBIDE NETWORK ON GRAIN BOUNDARIES. MACRO:GOOD, MINIMUM SOLUTION ANNEALING TEMPERATURE 1050C, SOAKING TIME 1/2 HRS, WATER QUENCHED. MELT SOURCE:AOD. WE CONFIRM THAT THE MATERIAL HAS BEEN TESTED AND FOUND TO BE FREE FROM RADIOACTIVE CONTAMINATION.COUNTRY OF ORIGIN: INDIA.

We hereby certify that the material described above has been tested and complies with the terms of order/contract.

WORKS INSPECTOR
K R K MURTHY

Heat: 46862

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>			
Date :	Sequence #:	QTY Affected :		MRB (QSI042) Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
Description Work Order Deviation		Disposition			
Root Cause Operator <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Presservation <input type="checkbox"/> Material <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Human Factors <input type="checkbox"/>		FAULT CATEGORY <div style="display: flex; justify-content: space-between;"> <div> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
		Other/Details:			